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| Work Orde December-03-13 | | 9886 | 03948-0 8109836 | ⁴³ *109 | 2836* | | hip | | ec ll | B | Page 1 |
| Revision ID: | D3948-043 | | B 1 0 9 0 0 | Accept | *N900 | 040 | 1100 |)* s | Setup Star | IV | S1* S2* |
| | 12/03/13 | Start Qty: 18.00 Req'd Qty: 18.00 | | | Cust Item J Customer: | D: | | | | i N | 5 / |
| | Process Pla | in: MLJ | Date: 13-12 | しく Tooling: | | ate: | <u>.</u> | | Run Stai | 1/1 | R1* |
| | | | | | | ate: | | | Sto | *N | R2* |
| Seguence ID/ Work Center ID |) | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| Draw Nbr | Rev | ision Nbr | | | | | | | | | |
| D3948 | В | | | | 1 | | | | | | · : |
| 100 | | | | 0.00 | | | | | | | |
| *100* Waterjet | | Memo | per Dwg D3948-3 | 0.00 | | | | 20 | ٥ | | Jm13-12- |
| 304.063 | I | Dwg Rev | : <i>B</i> _ | | | | | | | | |
| | | 2-Deburr | if necessary | | | | | | | | : |
| 110 | | QC2- Inspect parts of | f machine FAI/FAIB | 0.00 | | | | _ | | | |
| *110* QC Quality Control | | Memo | | 0.00 | * | | | 20 | | | Jm 13-12 |

| DQA: | | | Date: | | | | | | | | | | | A D (A | |
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| QA Closed: | | | Date: | | | WORK ORDER NON- | -CC | ONFO | RMANCE / U | PDATE | ١٨/، | ork Order up | odate only | AER | OSPACE |
| QA Closeu. | | | Date. | | | | | | | | VV (| ork Order up | date only | | |
| Work Orde | er: | | | | | DISPOSITION | | | | AGAINST | DE | PARTMENT | /PROCESS | | |
| | _ | | | | | Rework | | | Skid-tube | Crosstube | |] | Water Jet | Engineer | ring |
| Part N | No. | | | | | Scrap | | ! | Machining | Small Fab | | Pro | d. Eng. Coor. | Qua | - |
| | _ | | | | | Use-as-is | | Thern | noforming | Finishing | - | 4 | re/Packaging | | her |
| NCR I | ۷o | | | <u> </u> | | Suspected Unapproved | | | Large Fab | Composite | | | Supplier | | |
| | | | | | | | | | | | | | | | |
| Root | | | | | Desci | ription of work order update | | nitial | Act | tion | | Sign & | | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Desci | ription | | Date | Verification | QC Ins | pector |
| Design | Ш | | | | | | | | | | | | | | |
| Doc/Data | Н | | | | | | | | | | | | | | |
| Equip/Tooling | Ы | | | | | | E | | | | | | | | |
| Handling/Pre | Ш | | | | | | | | | | | | | | • |
| Material | Н | | | | | • | | | | | | | | | |
| Operator | Н | | | | | | | | | | | | | | |
| Offset/Setup | Н | | | | | | | | | | | | | | |
| Process | Н | | | | | | | | | | | | | | |
| Supplier | Н | | | | | | | | | | | | | | |
| Training | Н | | | | | | | | | | | | | | |
| Transport | Н | | | | | • | | | | | | | | | į |
| Unapproved | LL | | <u> </u> | | | | EAL | UT CAT | EGORY | | | 1 | | | |
| Landi | nø G | ear | | | | General | FAI | OLI CA | EGONT | · · · · · · · · · · · · · · · · · · · | | | | | |
| Carrai | | Bending | | | | Bend | |] Folio/P | rogram | | Г | Outside Dim | ensions [| Pressure/Fo | orcod |
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| | \vdash | Cracks | | | | Broken/Damage/Defect | | Hardwa | re | | 一 | Part Incorred | ⊢ | Temperatur | re/Cure |
| | - | Crimp/Kir | nk/Ripple | /Wave | | Burrs | | ł | on Incomplete/Ui | ngualified | H | Part Lost/Mi | | Weld | |
| | - | Cuffs | | • | | Contamination | | 1 | ions Incomplete/ | - | \vdash | Part Moved | - | Wrong Stoc | k Pulled |
| , | \square | Crushing | | | | Countersink | | i | ned/off center | | T | Positioned V | ∟ Vrong | | |
| | | Heat Trea | it | | | Cut Too Short | | Mislabe | | | \vdash | Power Loss/ | | Other | |
| | | Inspection | n Strip in | Tube | | Drawing | - | Misread | | | | | · | | |
| | - | Marks/Ch | | | | Drill Holes | | Off-set | | | | | | | |
| | | Turning S | equence | | | Finish | | 1 | Calibration | | | | | | |
| | — | Wave/Tw | ist in Tub | e | | Fit/Function | | Out of | Sequence | | | | -4 | | |

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

| 4 | Vork Order ID 109836 ecember-03-13 8:36:35 AM | | | *109 | 836* | | | | | Page 2 | |
|---|--|--------------------------------------|-----------------|-----------------------|--------------------------|-------------------|-----------------|------------------|------------------|----------------|-----------|
| Item ID: Revision ID: Item Name: | D3948-043 Plate, Anchor | | | Accept | *N900 | 04010 |) () * s | Setup Start | 171. | S1* S2* | = |
| Start Date: Required Date: Reference: | 12/03/13 | Start Qty: 18.00 Req'd Qty: 18.00 | *18* *18* | | Cust Item I Customer: | D: | | | | ., | |
| Approvals: | Process Pla | in: | Date: | Tooling: SPC (Y/N): | | ate: | - | Run Star Stop | " V t | ₹1* ₹2* | |
| Sequence ID/ Work Center II | D | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # Plan | | Reject Qty | Reject Number | Insp. Stamp | - |
| *120* *120* QC* Quality Control | | QC8- Inspect parts - seco | nd check | 0.00 Smr 0.00 Blal | | | <i>50</i> | | | <u></u> | , DAS |
| 130 *130* Small Fab Small Fab | | Memo COUNTERS | SINK AS PER DWG | 0.00 | | | 200 | | | 13/12/0 | 36 9-8 |
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| QA Closed: | | Date: | | | WORK ORDER NON- | -C(| ONFO | RMANCE / UP | | Wo | ork Order up | odate only | <u> </u> | A E R O S P A.C E |
| | | | | | DISPOSITION | | | | | | PARTMENT | | | |
| Work Orde | er: | | | | D137 03111014 | . | | | AGAINST | | PARTIVIENT | /PROCESS | | |
| Part I | No. | | | | Rework Scrap | | | Skid-tube Machining | Crosstube Small Fab | \neg | Pro | Water Jet d. Eng. Coor. | | Engineering Quality |
| | | | | | Use-as-is | | 1 | noforming | Finishing | \dashv | | re/Packaging | | Other |
| NCR I | No | · · · · · · · · · · · · · · · · · · · | | | Suspected Unapproved | | | Large Fab | Composite | | 1100,0101 | Supplier | | |
| D4 | | - ₁ | 1 | | | | | | | | | | | |
| Root | D.4. | | ۵. | Desci | ription of work order update | i | Initial | Actio | | - 1 | Sign & | _ | | |
| Cause | Date | Step | Qty | | or non-conformance | Ch | nief Eng | Descrip | otion | | Date | Verification | <u>1</u> | QC Inspector |
| Design | | | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | 1 | | | | |
| Equip/Tooling Handling/Pre | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | |
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| Training | | | | | | | | | | 1 | | | | |
| Transport | | | | | | | | | | - 1 | | | | |
| Unapproved | | | | | | | | | | | | | | |
| | <u>-</u> | <u> </u> | l | | | FΔI | UIT CAT | TEGORY | | 1 | | <u> </u> | | |
| Landi | ng Gear | | ~ | | General | | <u> </u> | | | | | | | |
| | Bending | ζ | | | Bend | | Folio/P | rogram | ſ | | Outside Dim | ensions | | Pressure/Forced |
| | Centre | Not Concei | ntric | | BOM/Route | | Grain | - G | İ | | Over/Under | . | | Set-up |
| | Cracks | | | | Broken/Damage/Defect | | Hardwa | re | | - | Part Incorred | | | Temperature/Cure |
| | Crimp/ | (ink/Ripple | /Wave | | Burrs | | 1 | on Incomplete/Ung | ualified | - | Part Lost/Mi | , , | _ | Weld |
| | Cuffs | | | | Contamination | - | 1 | ions Incomplete/Un | · j_ | $\overline{}$ | Part Moved | H | - | Wrong Stock Pulled |
| | Crushin | g | | | Countersink | | 1 | ned/off center | | _ | Positioned V | | | TVV ONB OLOGIC CARCA |
| | Heat Tr | eat | | | Cut Too Short | | Mislabe | | | $\overline{}$ | Power Loss/ | | | Other |
| | Inspect | ion Strip in | Tube | | Drawing | | Misread | | £ | | -7 | ٠ [| | |
| | Marks/ | Chatter | | | Drill Holes | | Off-set | | | • | | | | |
| | Turning | Sequence | | | Finish | | Out of (| Calibration | | - | | | | |
| | Wave/T | wist in Tub | oe | | Fit/Function | | Out of S | Sequence | | - | | | _ | |

| Work Orden December - 03 - 1. | | | | *109 | 836* | | | | | | | Page 3 |
|---|---|---|------------------------|---------------------------------|--------------------------|------------|--------------|--------------|------------|---------------|------------------|----------------|
| Item ID: Revision ID: | D3948-043 | | | Accept | *N900 | 040 | 100 | ገ* | Setup | Start Stop | *N: | S1* |
| Item Name: Start Date: Required Date: Reference: | Plate, Anchor 12/03/13 : 12/10/13 | Start Qty: 18.00 Req'd Qty: 18.00 | *18* *18* | | Cust Item I Customer: | D: | | | | Stop | *N: | S2* |
| Approvals: | Process Pla | n: | Date: | Tooling:SPC (Y/N): | | ate: | | | Run | Start Stop | *N *N | R1* R2* |
| Sequence ID/ Work Center II 150 *150* QC Quality Control | D | Operation Description QC5- Inspect part comple | eteness to step on W/O | Set Up/ DAS Run Hours 0.00 9-89 | Tool ID | Tool# | Plan Code | Accep Qty | t Re Qt | | Reject Number | Insp. Stamp |
| 180 *180* Packaging Packaging | | Pick Kit | | 0.00 | | | | <u> 20</u> x | | | | 13/12/ |
| 190 | | | | 0.00 | | | | | | | | J |

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| QA Closed: | | Date | <u>:</u> | | WORK ORDER NON- | -((| JNFO | RIVIANCE / UI | | Wo | ork Order up | odate only | | AEROSPACE |
| Work Orde | or: | | | | DISPOSITION | | | | AGAINST | DE | PARTMENT | /PROCESS | | |
| WOIR Olde | | | | - | Rework | ١ | | Skid-tube | Crosstube | | | Water Jet | Г | Engineering |
| Part N | No. | | | | Scrap | | | Machining | Small Fab | | Pro | d. Eng. Coor. | - | Quality |
| | | | | _ | Use-as-is | | | noforming | Finishing | \vdash | | re/Packaging | _ | Other |
| NCR N | No | | | _ | Suspected Unapproved |] | | Large Fab | Composite | - | | Supplier | \vdash | |
| Root | | | | Desci | ription of work order update | | l Initial | Act | ion | | Sign & | | | |
| Cause | Dat | e Step | Qty | | or non-conformance | Ch | nief Eng | Descr | ription | | Date | Verificatio | n | QC Inspector |
| Design | | | | | | | | - | | | | | | |
| Doc/Data | | | | | | | | | | | | | | |
| Equip/Tooling | Ш | ļ | | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | |
| Operator | | | | | | 1 | | | | İ | | | | |
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| Landi | ng Gear | | | | General | | _ | | | | | | | |
| | Bendi | ng | | | Bend | | Folio/F | rogram | | | Outside Dim | ensions | | Pressure/Forced |
| | Centro | Not Conce | entric | | BOM/Route | | Grain | | | | Over/Under | tolerance | | Set-up |
| | Cracks | 5 | | | Broken/Damage/Defect | | Hardwa | re | | | Part Incorred | ct | | Temperature/Cure |
| | Crimp | /Kink/Rippl | e/Wave | | Burrs | | Inspect | ion Incomplete/Ur | nqualified | | Part Lost/Mi | ssing | | Weld |
| | Cuffs | | | | Contamination | | Instruct | ions Incomplete/L | Jnclear | | Part Moved | | | Wrong Stock Pulled |
| | Crush | ing | | | Countersink | | Misalig | ned/off center | | | Positioned V | Vrong | | |
| | Heat 7 | Treat | | | Cut Too Short | | Mislabe | eled | | | Power Loss/ | Surge | | Other |
| | Inspec | ction Strip ir | n Tube | | Drawing | | Misread | 1 | • | | | | | |
| | Marks | /Chatter | | | Drill Holes | | Off-set | | | • | | | | |
| | Turnir | ng Sequence | 2 | | Finish | | Out of (| Calibration | | • | | | | |
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| Work Ord December-03-1 | | | | *109 | 836* | | | | | | Page 4 |
|--|----------------------------|---|----------------------------|--|---------------------------|-------------|--------|---------------|-------------------|------------------|----------------|
| Item ID: Revision ID: Item Name: | D3948-043 Plate, Anchor | | | Accept | *N900 | 0401 | ሰበ | k s | etup Star Stop | I VI . | S1* S2* |
| Start Date: Required Date: Reference: | 12/03/13 12/10/13 | Start Qty: 18.00 Req'd Qty: 18.00 | *18* *18* | | Cust Item II Customer: | D: | | | | | |
| Approvals: | | n: | | | | te: | | R | un Star Stop | 11/1 | ₹1* ₹2* |
| Sequence ID/ Work Center II 200 *200* QC Quality Control | D | Operation Description QC5- Inspect part comple Memo | eteness to step on W/O | Set Up/ Run Hours 0.00 DA 27 0.00 9-8 | 7 | Tool# I | Code (| Accept Oty | Reject Qty | Reject Number | Insp. Stamp |
| 210 *210* Packaging Packaging | | Identify as per dwg & Sto Memo | ock Location: <u>570</u> 7 | 5 0.00 0.00 | | | _ | 20x | DAS 28 9-89 | 13-12 | 2 <u>-5</u> |
| 220 * 27 * 27 * QC Quality Control | | QC21- Final Inspection - Memo | Work Order Release | 0.00 | | | _ | | 13/1 | 2/9 | # |
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| DQA: | | | Date: | | | | | | _ | | | | | |
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| QA Closed: | | | Date: | | | WORK ORDER NON | -C(| ONFO | RMANCE / UI | PDATE | Wa | ork Order up | odate only | AEROSPACE |
| | | | | | | DISPOSITION | | | | ACAINST | | PARTMENT | | |
| Work Orde | er: | | | | | DISPOSITION | _ | | | AGAINST | υE | PARTIVIENT/ | /PROCESS | |
| | | | | | | Rework | | | Skid-tube | Crosstube | | | Water Jet | Engineering |
| Part N | No | | | | | Scrap | |] | Machining | Small Fab | | Pro | d. Eng. Coor. | Quality |
| | | | | | | Use-as-is | | Thern | noforming | Finishing | | Rec/Stor | e/Packaging | Other |
| NCR N | No | | | | | Suspected Unapproved | | | Large Fab | Composite | | J | Supplier | |
| Root | | | | | Descr | ription of work order update | | Initial | Act | ion | | Sign & | | |
| Cause | D. | ate | Step | Qty | | or non-conformance | Ch | nief Eng | Descr | ription | | Date | Verification | QC inspector |
| Design | | | | | | | | | | • | | | | |
| Doc/Data | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | l | | | | | | ÷ | |
| Handling/Pre | _ | | | | | | | | | | | | | |
| Material | _ | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | • | |
| Offset/Setup | _ | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | |
| Supplier | \dashv | | | | | | | | | | | | | |
| Training Transport | \dashv | 1 | | | | | | | | | | | | |
| Unapproved | - | | | | | | | | | | | | | |
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| Landir | ng Gear | | | | | General | | | | - | | | | |
| | Ben | ding | | | | Bend | Г | Folio/P | rogram | | Γ | Outside Dim | ensions | Pressure/Forced |
| | Cent | re Not | Concen | ntric | | BOM/Route | | Grain | • | | _ | Over/Under | <u> </u> | Set-up |
| | Crac | ks | | | | Broken/Damage/Defect | | Hardwa | re | | | Part Incorrec | — | Temperature/Cure |
| | Crim | p/Kink | /Ripple | /Wave | | Burrs | Г | Inspecti | on Incomplete/Ur | nqualified | | Part Lost/Mi | ssing | Weld |
| | Cuff | S | | | | Contamination | | Instruct | ions Incomplete/L | Jnclear | | Part Moved | | Wrong Stock Pulled |
| | Crus | hing | | | | Countersink | |]Misalig | ned/off center. | | | Positioned W | | |
| | Hea | t Treat | | | | Cut Too Short | | Mislabe | led | | | Power Loss/S | Surge | Other |
| | | | Strip in | Tube | | Drawing | | Misread | 1 | | | | | |
| | _ | ks/Cha | | | | Drill Holes | <u>L</u> | Off-set | | | | | | |
| | | • | quence | | | Finish | | 4 | Calibration | | | | | |
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| Picklist Print December-03-13 8:36:38 AM | | | | | | | | | | | | Page 1 |
|--|---------------------|-------------|---------------------|----------------------------|-----------------|---------------------------|----------------|--------------------------------|--------------|------------------|--------------------------|----------------|
| Work Order ID: 109836 Parent Item: D3948-043 | | | 10983 | 6* 3-043* | | | | | | | | 1 |
| Parent Item Name: Plate, Anchor | | • | 7.1340 |)=(<i>14</i> .) | | | | art Date: 12/ tart Qty: 18. | | | d Date: 12 ed Qty: 18 | |
| Comments: IPP RevA: New | issue DD verified b | y:EC | | | | | | | | w | | <u></u> |
| Component Item ID/ Replacement Item ID Item ID | nt Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
| M304S16GA *M304S16GA* 304/316 Sheet .063 | Purchased | No | | | 100 | sf | 255.9740 | 0.0218 | <u>(</u>) | | , | Jm13-17 |
| | | | Location MAT020 | | 2 | | Loc Code | - - | 12691- | - - - - | | , Dec |
| MS21059L3 *MS21059I 3* Nut Piate | Purchased | No | | | 180 | Each | 90.0000 | 1 ** | 18 | _(3_ | /12/ | 05 9-89 |
| | | | Location ST316 | 124291 125535 | Loc (| Oty 90 7 3 | Loc Code | - - | | - - | | |
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| QA Closed: | | | Date: | | | WORK ORDER NON | -C(| ONFO | RMANCE / U | PDATE | W | ork Order up | ndate only | ¬ · | AEROSPACE |
| | | | | | | DISPOSITION | | | | AGAINST | • • • • | PARTMENT | | | |
| Work Orde | er: | | | | | | 1 | | | | | 7 | _ | _ | |
| D A | | | | | | Rework | | | Skid-tube | Crosstube | $\overline{}$ | _ | Water Jet | _ E | ngineering |
| Part N | NO | | | | | Scrap | | | Machining | Small Fab | | 4 | d. Eng. Coor. | 4 | Quality |
| NCR N | lo · | | | | | Use-as-is Suspected Unapproved | | Inern | noforming Large Fab | Finishing Composite | - | Rec/Stor | re/Packaging | 4 | Other |
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| Root | | | | | Descr | iption of work order update | Ti | Initial | Act | ion | - | Sign & | | T | |
| Cause | Da | ite | Step | Qty | | or non-conformance | 1 | nief Eng | | ription | | Date | Verification | | QC Inspector |
| Design | | | | | | | | | | -' | | | | 1 | |
| Doc/Data | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | |
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| Process | | | | | | • | | • | | | | , | | | |
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| Training | | | | | | | | | | | | | | | |
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| Landir F | ng Gear | | | | | General | _ | 1 | | | _ | ד | _ | _ | |
| | Bend | _ | _ | - | - | Bend | _ | 1 | rogram | | <u> </u> | Outside Dim | | - | ssure/Forced |
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| } | Crack | | /p: - L | 0.41 | H | Broken/Damage/Defect | | Hardwa | | | | Part Incorred | | ┥ | nperature/Cure |
| } | _ | - | /Ripple/ | wave | \vdash | Burrs | <u> </u> | 1 | on Incomplete/Ur | • | _ | Part Lost/Mis | | _ We | |
| } | Cuffs | | | | _ | Contamination | <u> </u> | 1 | ions Incomplete/U | Inclear | _ | Part Moved | | Wro | ong Stock Pulled |
| } | Crusi | ning Treat | | | - | Countersink | | 1 - | ned/off center | | <u> </u> | Positioned W | _ | _ | |
| } | _ | | Strip in ' | Tubo | \vdash | Cut Too Short | \vdash | Mislabe | | | | Power Loss/S | Surge | Oth | er |
| } | ' | ction s | ٠. | rube | | Drawing Drill Holes | \vdash | Misread | 1 | | | | | | |
| } | | | quence | | | Finish | <u> </u> | Off-set | Talibuatia- | | | | | | |
| } | | | t in Tub | ۵ | | Fit/Function | \vdash | 1 | Calibration | | | | ., | | |
| | | | | | | | | | | | | | | | |

| DART AEROSPACE LTD | Work Order: | 109836 |
|------------------------------|--------------|-------------|
| | | |
| Description: Plate | Part Number: | D3948-3 |
| Inspection Dwg: D3948 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| X | First Article | Prototype |
|---|---------------|-----------|
|---|---------------|-----------|

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|---------------|---------------------|--------|--------|-------------------------|----------|
| Ø0.098 | +0.004/-0.001 | 0,098" | _ | | V | JAMOI |
| Ø0.250 | +0.005/-0.001 | 0.250 | _ | | V | |
| 0.688 | +/-0.010 | 0.690" | _ | | V | |
| 1.254 | +/-0.010 | 1.257 | _ | | V | |
| 0.344 | +/-0.010 | 0.348" | _ | | V | |
| 1.25 | +/-0.030 | 1.254 | _ | | V | |
| 2.51 | +/-0.030 | 2 517 | | | V | |
| 0.63 | +/-0.030 | 0.633 | | | V | |
| 0.063 | +/-0.010 | 0.058" | | | V | |
| | | | | | | |
| | | | | | | |
| | | | ÷ | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| Measured by: Jm | Audited by: Sin | Prototype Approval: | N/A |
|-----------------|-----------------|---------------------|-----|
| Date: 13-12-3 | Date: B// |) y Date: | N/A |

| Rev | Date | Change | | Revis | | | App | roved |
|-----|----------|-----------|---------------|-------|---|----------|-----|-------|
| Α | 09.07.29 | New Issue | P/O D3948-043 | KJ | X | <u> </u> | W | |
| | | | | | | 7 | ~ | |

| DQA: | | · · · · · · · · · · · · · · · · · · · | Date: | | | | | | | | | | |
|-------------------------------|--------------------------|---------------------------------------|----------|----------|-------|------------------------------|--------------------|----------|---------------------|-----------|---------------|---------------|--------------------|
| QA Closed: | | | Date: | | | WORK ORDER NON | -C(| ONFO | RMANCE / UP | | ork Order up | odate only | AEROSPACE |
| | | | | • | , | DISPOSITION | • | | | | EPARTMENT, | · | -1 - |
| Work Orde | er: _ | | | | | | | | | AGAINST D | _ | , r NOCE33 | <u> </u> |
| | | | | | | Rework | | | Skid-tube | Crosstube | | Water Jet | Engineering |
| Part N | ۷o | | | | | Scrap | | | Machining | Small Fab | Pro | d. Eng. Coor. | Quality |
| | | | | | | Use-as-is | | Therr | noforming | Finishing | Rec/Sto | re/Packaging | Other |
| NCR I | No | | | | | Suspected Unapproved | | | Large Fab | Composite | | Supplier | |
| Doot | | | | | Dana | | 1 " | <u> </u> | | | T c: 0 | | |
| Root | | Data | Cton | | Desci | ription of work order update | 1 | Initial | Actio | | Sign & | ., ., | |
| Cause | \vdash | Date | Step | Qty | | or non-conformance | Cr | nief Eng | Descrip | otion | Date | Verification | QC Inspector |
| Design | \vdash | | | | | | ł | | | | | | |
| Doc/Data | \dashv | | | | | | | | | | | | |
| Equip/Tooling Handling/Pre | \vdash | | | | | | | | | | | | |
| · | H | | | | | | | | | | | | |
| Material | H | | | | | | | | | | | | |
| Operator Offset/Setup | Н | | | | | | | | | | | | |
| Process | Н | | | | | | | | | | | | |
| Supplier | H | | | | | | | | | | | | |
| Training | \vdash | | | | | | | | | | | | |
| Transport | Н | | · | | | | | | | | | | |
| Unapproved | \Box | | | | | | | | | | | | |
| | | | <u> </u> | <u> </u> | | | FA | ULT CA | TEGORY | | . I | 1 | |
| Landi | ng Ge | ar | | | | General | | | | | | | |
| | В | ending | | | | Bend | | Folio/F | rogram | | Outside Dim | ensions | Pressure/Forced |
| | c | Centre Not Concentric | | | | BOM/Route | | Grain | | | Over/Under | tolerance | Set-up |
| | Cracks | | | | | Broken/Damage/Defect | | Hardwa | are | | Part Incorred | ct | Temperature/Cure |
| | Crimp/Kink/Ripple/Wave | | | | | Burrs | Г | Inspect | ion Incomplete/Unq | ualified | Part Lost/Mi | issing | Weld |
| | Cuffs | | | | | Contamination | | Instruct | tions Incomplete/Un | nclear | Part Moved | | Wrong Stock Pulled |
| | Crushing | | | | | Countersink | | Misalig | gned/off center | | Positioned V | Vrong | |
| | Heat Treat | | | | | Cut Too Short | | Mislabe | eled | | Power Loss/ | Surge | Other |
| | Inspection Strip in Tube | | | | | Drawing | | Misrea | d | | | | |
| | Marks/Chatter | | | | | Drill Holes | | Off-set | | | | | |
| | Turning Sequence | | | | | Finish | Out of Calibration | | | | | | |
| | Wave/Twist in Tube | | | | | Fit/Function | | Out of | Sequence | | | | |

^{*} H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

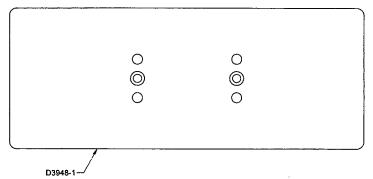
PARTS LIST ITEM QTY

D

DESCRIPTION P/N D3948-041 PLATE, ANCHOR PLATE D3948-1 2 MS21059L3 NUTPLATE (OR MS21059-3)
4 MS20426AD3-3 RIVET 000 000

2

-MS21059L3 (1) MS20426D3-3 (2) 2 PL



109836 MLJ 13-12-63

D3948-041 PLATE, ANCHOR

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3948-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.10 lbs

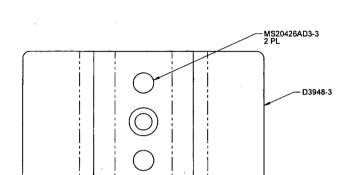
| | | | | | 1 | | | | |
|---------------------|-------------------------------|---|--|--|-----------|--|--|--|--|
| -3F NOV 0.040 (Z | W MADE FROM N A8-3, A8-5). | 304 SS (ZN A8-5), 0.063 THICK WAS 043/-3/-3F WIDER (ZN B6-4, B6-5) | СР | 09.06.08 | ł | | | | |
| NEWIS | SUE | | CP 09.05.13 | | | | | | |
| | | DESCRIPTION | BY | DATE | ı | | | | |
| ų. | 971 | DART AEROSPA | CEL | TD. | A | | | | |
| ١ | 9 | | | | ľ | | | | |
| ED | 13 | DRAWING NO. | | REV. B | l | | | | |
| PPR. | 91 | D3948 | | SHEET 1 OF 5 | İ | | | | |
| VED | 143 | TITLE | | SCALE | ı | | | | |
| PR. | -# | PLATE, ANCHOR | | NTS | ı | | | | |
| 09.0 | 6.08 | COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRANTA AND COMPRETATIVE ON THE EMPESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COPIED OF COMMUNICATION ON MY TRUE POTRION WITHOUT WRITTEN PERMISSION FROM DUST ARROPHICE LTD. | | | | | | | |
| | NEWIS I ED PPR. VED PR. | NEW ISSUE | DESCRIPTION DART AEROSPA HAWKESBURY, ONTARI DARY DARY DARY DARY DARY DARY DARY DARY | DESCRIPTION BY DART AEROSPACE L HAWKESBURY, ONTARIO, CANA DARY AEROSPACE L HAWKESBURY, ONTARIO, CANA D3948 VED D3948 VED TITLE PLATE, ANCHOR 09.06.08 | NEW ISSUE | | | | |

5

| DQA: | | Date: | | | | | | | | | | | | |
|-----------------------|------------------------|----------------|-------|-------------|------------------------------|-----|----------|----------------------------|-----|---------------|---------------------------------------|---|--|--|
| QA Closed: | | Date: | | | WORK ORDER NON | -C(| ONFO | RMANCE / UPDATE | W | ork Order up | odate only | AEROSPACE | | |
| | | | | | DISPOSITION | | | VEVINE | | PARTMENT | · · · · · · · · · · · · · · · · · · · | | | |
| Work Orde | er: | | | | | _ | | AGAINS | | PARTIVIENT, | /PROCE33 | | | |
| | | | | | Rework | | | Skid-tube Crosstube | | | Water Jet | Engineering | | |
| Part N | No | | | | Scrap | | | Machining Small Fal | ╙ | -1 | d. Eng. Coor. | Quality | | |
| | | | | | Use-as-is | - | Therr | noforming Finishin | - ⊢ | Rec/Sto | re/Packaging | Other | | |
| NCR N | No | | | | Suspected Unapproved |] | | Large Fab Composite | 2 |] | Supplier | | | |
| Root | | | | Desci | ription of work order update | | Initial | Action | | Sign & | | | | |
| Cause | Date | Step | Qty | | or non-conformance | Ct | nief Eng | Description | | Date | Verification | QC Inspector | | |
| Design | | | | | • | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | | |
| Equip/Tooling | | ' | | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | , | | | |
| Material | | | | | | | | | | | | | | |
| Operator | _ | | | | | İ | | | | | | | | |
| Offset/Setup | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | |
| Supplier | | | | | | 1 | | | | | | | | |
| Training Transport | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | |
| оларріочеа | <u> </u> | | 11 | | | ΕΛ | IIIT CAT | I TEGORY | | <u> </u> | | L | | |
| Landir | ng Gear | | · | | General | 10 | OLI CA | ILOOKI | | | | | | |
| ſ | Bendin | g | | | Bend | Г |]Folio/F | Program | | Outside Dim | ensions | Pressure/Forced | | |
| | Centre | - Not Conce | ntric | | BOM/Route | | Grain | | | Over/Under | | Set-up | | |
| | Cracks | | | | Broken/Damage/Defect | | Hardwa | ire | | Part Incorred | | Temperature/Cure | | |
| | Crimp/Kink/Ripple/Wave | | | | Burrs | | Inspect | ion Incomplete/Unqualified | | Part Lost/Mi | | Weld | | |
| | Cuffs | | | | Contamination | | 1 | ions Incomplete/Unclear | | Part Moved | | Wrong Stock Pulled | | |
| | Crushing | | | | Countersink | | 1 | ned/off center | | Positioned V | ـــــ Vrong | _ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ ~ | | |
| | Heat Treat | | | | Cut Too Short | | Mislabe | eled | | Power Loss/: | Surge | Other | | |
| | Inspect | ion Strip in | Tube | | Drawing | | Misread | 1 | • | • | - L | - . | | |
| | Marks/ | Chatter | | | Drill Holes | | Off-set | | | | | | | |
| | | Sequence | | | Finish | | Out of 0 | Calibration | | | | | | |
| | Wave/Twist in Tube | | | | Fit/Function | 1 | Out of | Sequence | | | | | | |

PARTS LIST

| ITEM | -043 | P/N | DESCRIPTION |
|------|------|--------------|-------------------------|
| 1 | X | D3948-043 | PLATE, ANCHOR |
| 2 | 1 | D3948-3 | PLATE |
| 3 | 1 | MS21059L3 | NUTPLATE (OR MS21059-3) |
| 4 | 2 | MS20426AD3-3 | RIVET |





D3948-043 PLATE, ANCHOR

D.

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3948-043" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.06 lbs

8

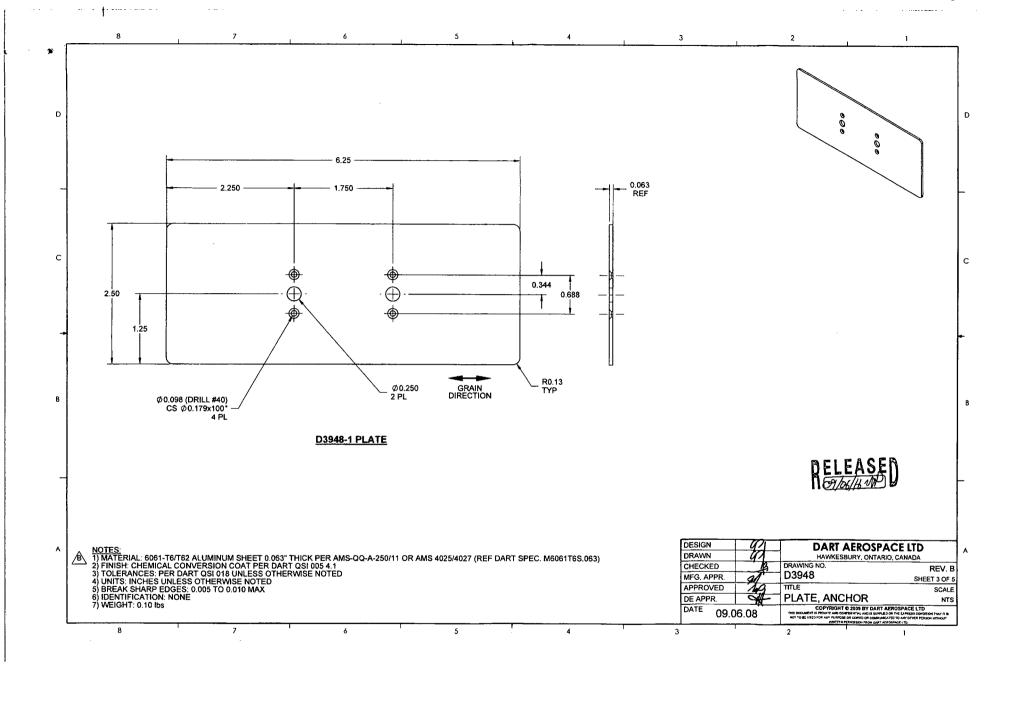
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DESIGN DRAWN DRAWING NO. CHECKED REV. B D3948 MFG. APPR. SHEET 2 OF S APPROVED TITLE SCALE PLATE, ANCHOR

COPYRIGHT © 2009 BY DART AEROSPACE LTD

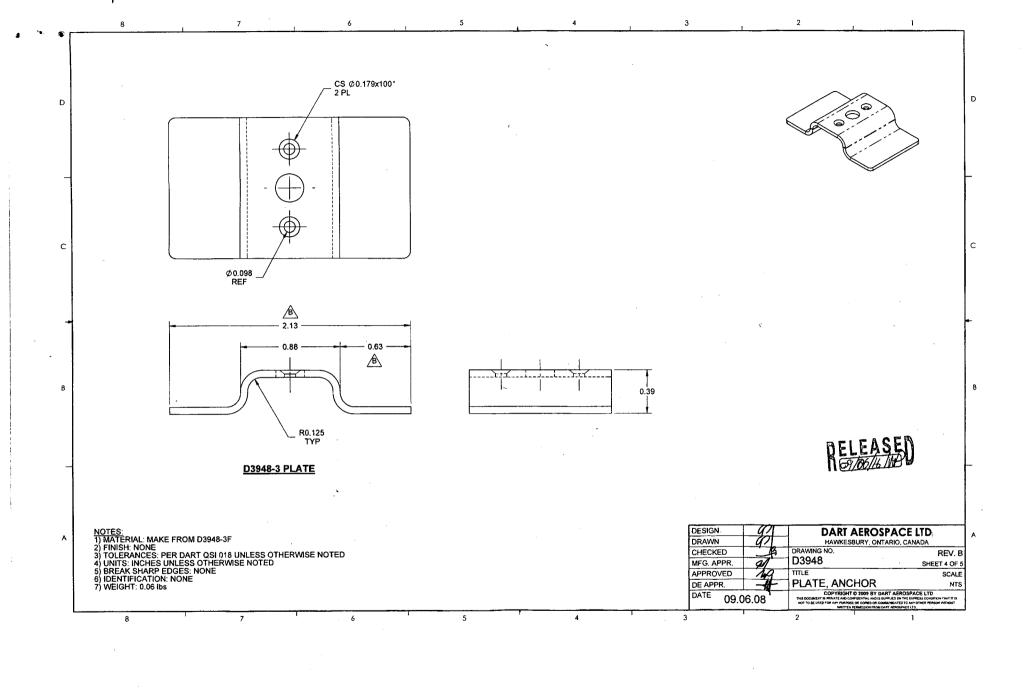
THE GOGNAMET IS PRIVATE AND CONFERENCE AND IS AUPPLES ON THE EXPRESS COMING
TO BE USED FOR ANY PLATFORM COMPILED AND SHELL THE TO THE RESERVE. DE APPR. NTS DATE 09.06.08

4 5

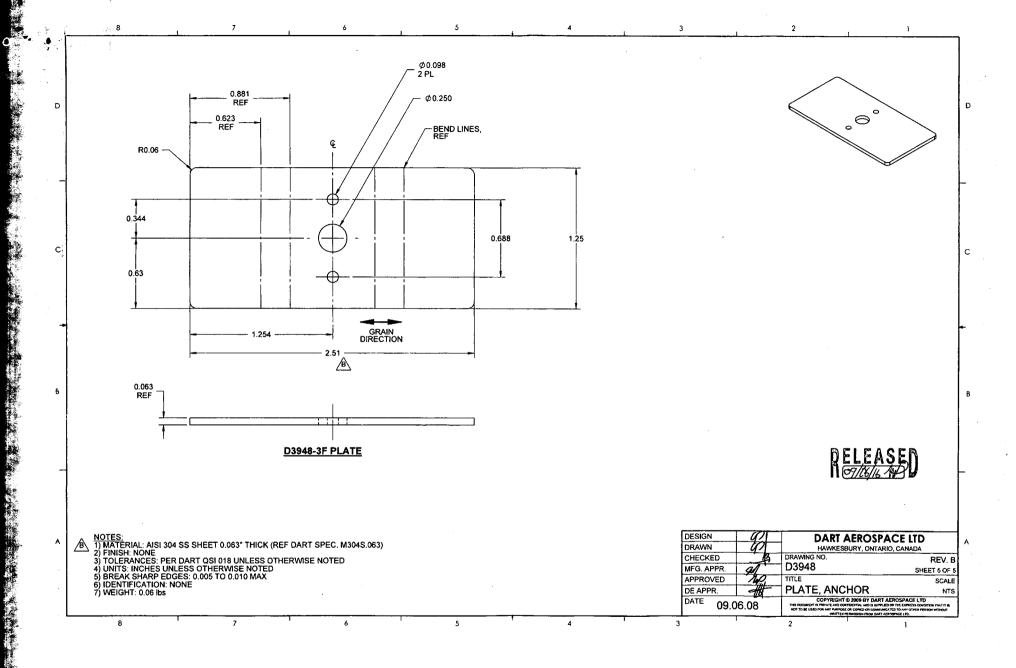
| DQA: | | Date: | | | - · · · · · · · · · · · · · · · · · · · | | | | | | | | | |
|----------------------|--------------------------|--------------|-------------|-------|---|---------------|-----------|------------------------|-----------|----------------|---------------|--------------------|--|--|
| QA Closed: | | Date: | | | WORK ORDER NON- | -C(| ONFO | RMANCE / UPDA | | (anle Ondan en | | AEROSPACE | | |
| QA Closed. | | Date. | | | | | ſ | | V | ork Order up | date only | | | |
| Work Orde | er: | | | | DISPOSITION | | | A | GAINST D | EPARTMENT, | /PROCESS | | | |
| | | | | _ | Rework | 1 | | Skid-tube Cr | osstube | 7 | Water Jet | Engineering | | |
| Part N | No. | | | | Scrap | | | — | mall Fab | Pro | d. Eng. Coor. | Quality | | |
| | | | | _ | Use-as-is | | Therr | noforming F | inishing | ⊣ | re/Packaging | Other | | |
| NCR N | No | | | _ | Suspected Unapproved |] | | Large Fab Cor | mposite 🗌 | | Supplier | | | |
| | | | т т | | | 1 | | | | | | | | |
| Root | | | 1 1 | Descr | ription of work order update | 1 | Initial | Action | | Sign & | | | | |
| Cause | Date | Step | Qty | | or non-conformance | Ch | nief Eng | Description | n | Date | Verification | QC Inspector | | |
| Design | | | | | | ļ | | | | | | <u> </u> | | |
| Doc/Data | | | | | | | | | | | | | | |
| Equip/Tooling | \vdash | | | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | | |
| Material Operator | | 1 | | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | |
| Transport | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | |
| | | | | | | FA | ULT CAT | TEGORY | | | | | | |
| Landi | ng Gear | | | | General | | | | | | | | | |
| : | Bendin | g | | | Bend | | Folio/F | rogram e | | Outside Dim | ensions | Pressure/Forced | | |
| | Centre | Not Conce | ntric | | BOM/Route | | Grain | | | Over/Under | tolerance | Set-up | | |
| | Cracks | | | | Broken/Damage/Defect | | Hardwa | re | | Part Incorred | ct | Temperature/Cure | | |
| | Crimp/Kink/Ripple/Wave | | | | Burrs | <u> </u> | Inspect | on Incomplete/Unquali | ified | Part Lost/Mi | ssing | Weld | | |
| | Cuffs | | | | Contamination | | Instruct | ions Incomplete/Unclea | ar | Part Moved | | Wrong Stock Pulled | | |
| | Crushing | | | | Countersink | _ | 1 | ned/off center | L | Positioned V | Vrong | _ | | |
| | Heat Treat | | | | Cut Too Short | | Mislabe | eled | | Power Loss/ | Surge | Other | | |
| | Inspection Strip in Tube | | | | Drawing | $\overline{}$ | Misread | | | | | | | |
| | Marks/Chatter | | | | Drill Holes | Off-set | | | | | | | | |
| | | Sequence | | | Finish | _ | - | Calibration | | | | | | |
| | Wave/ | Twist in Tul | be | | Fit/Function | 1 | lOut of 9 | Seguence | | | | | | |



| DQA: | | | . Date: | <u> </u> | | WORK ORDER NON-CONFORMANCE / UPDATE | | | | | | | | | ``DART |
|---------------|--------------------------|-----------------------|---------|----------|------|-------------------------------------|-----------------|-------------------|---------------------|---------------------|----|---------------------|-----------------------|--------|--------------------|
| QA Closed: | | | Date: | | | WORK ORDER NON- | | JINFUI | AIVIAINCE / U | | Wo | ork Order up | odate only | \neg | AEROSPACE |
| Work Orde | ar. | | | | | DISPOSITION | | | | AGAINST | DE | PARTMENT | /PROCESS | | |
| | • | | | | | Rework | | | Skid-tube | Crosstube | | | Water Jet | | Engineering |
| Part f | ١٥. | | | | | Scrap | | Machining Small F | | | | | d. Eng. Coor. | | Quality |
| NCR I | No. | | | | | Use-as-is Suspected Unapproved | | Thern | noforming Large Fab | Finishing Composite | | Rec/Stor | re/Packaging Supplier | | Other |
| Root | | | | | Desc | ription of work order update | | Initial | Action | | | Sign & | | П | |
| Cause | | Date | Step | Qty | | or non-conformance | 1 | nief Eng | | ription | | Date | Verification | ۱ | QC Inspector |
| Design | | | | | | | | | | | | | : _ | ヿ | |
| Doc/Data | | | | | | | | | ! | | | | | | |
| Equip/Tooling | |] | | | - | | | | | | | | | ļ | |
| Handling/Pre | | | | | | | | | | | | | | | |
| Material | J | | | | | | | | | | | 1 | | İ | |
| Operator . | * | | | | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | | | | | |
| Process | |] | | | | | | | | | | | | | |
| Supplier | | | Ì | | | | | | | | | | | | |
| Training | | | - | | | | | | | | | | | | |
| Transport | | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | | |
| | | | | | | | FA | ULT CAT | EGORY | | | | | | |
| Landi | ng (| Gear | | | | General | | | | | | • | | | |
| | | Bending | | | | Bend | | Folio/F | rogram | | | Outside Dim | ensions | | Pressure/Forced |
| | | Centre Not Concentric | | | | BOM/Route | | Grain | | | | Over/Under | tolerance | \neg | Set-up |
| | | Cracks | | | | Broken/Damage/Defect | | Hardwa | re | | | Part Incorred | ct | | Temperature/Cure |
| | Crimp/Kink/Ripple/Wave | | | | | Burrs | | Inspect | on Incomplete/U | nqualified | | Part Lost/Mi | ssing | | Weld |
| | Cuffs | | | | | Contamination | | Instruct | ions Incomplete/I | Unclear | | Part Moved | | | Wrong Stock Pulled |
| | Crushing | | | | | Countersink | | Misalig | ned/off center | Ì | | Positioned V | ر Vrong | _ | - |
| | Heat Treat | | | | | Cut Too Short | | Mislabe | led | Ì | | Power Loss/: | | \Box | Other |
| | Inspection Strip in Tube | | | | | Drawing | Misread | | | | | | _ | *** | |
| | | Marks/Ch | natter | | | Drill Holes | | | | | | | | | |
| | Turning Sequence | | | | | Finish | | | Out of Calibration | | | | | | |
| | Wave/Twist in Tube | | | | | Fit/Function | Out of Sequence | | | | | | | | |



| DQA: | | | Date: | | | WORK ORDER MON | -CONFORMANCE / UPDATE | | | | | | | • | |
|---------------|--------------------------|---------------------|------------|-------|-------|--------------------------------|-----------------------|------------------|------------------------|-----------|--------------|----------|---------------|-------------|--------------------|
| QA Closed: | | | Date: | | | WORK ORDER NON- | -((| JINFOI | RIVIANCE / UI | | Vork Ord | ler ur | odate only | \neg | AEROSPACE |
| | | | | | · | DISPOSITION | | | | AGAINST D | EPARTN | IENT, | /PROCESS | | |
| Work Orde | er: _ | | | | - | , ,— | | | | _ | _ | | _ | _ | |
| D =t A | | | | | | Rework | | | Skid-tube | Crosstube | _ | _ | Water Jet | - | Engineering |
| Part N | vo. – | | | | | Scrap | | | Machining | Small Fab | | | d. Eng. Coor. | - | Quality |
| NCR N | do. | | | | | Use-as-is Suspected Unapproved | | inern | noforming Large Fab | Finishing | re/Packaging | \dashv | Other | | |
| NCN | v o | | | | | Suspected Ollapproved | | | raige Fab | Composite | | | Supplier | _ | |
| Root | | | | | Desci | ription of work order update | 1 | nitial | Action | | Sign | & | | Т | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Descr | ription | Da | te | Verification | . | QC Inspector |
| Design | | | | | | | | | | | | 1 | | \exists | |
| Doc/Data | | | | | | | | | | | | | | - 1 | |
| Equip/Tooling | | | | | | | | | | | | ļ | | 1 | |
| Handling/Pre | | | | | | | | | | | | | | | |
| Material | Ш | | | | | | | | | | | | | | |
| Operator | Ш | | | | | , | | | • | | | | · | | |
| Offset/Setup | | | | | | | | J. | | | | ŀ | | | |
| Process | | | | | | | | | | | | | 1 | | |
| Supplier | | | | | | | | | | | | ı | | | |
| Training | | | | | | | | | | | | | | | |
| Transport | | | | | | | | | | | | | | - 1 | |
| Unapproved | | | | | | | | | | | | İ | | | |
| | | | | | | | FAI | ULT CAT | EGORY | | <u> </u> | | | | |
| Landi | ng Ge | ear | | | | General | | _ | | | | | | | |
| | E | Bending | | | | Bend | | Folio/P | rogram | | Outsid | e Dim | ensions | \neg | Pressure/Forced |
| | | Centre No | t Concer | ntric | | BOM/Route | | Grain | | | Over/L | Jnder | tolerance | \exists : | Set-up |
| | | Cracks | | | | Broken/Damage/Defect | | Hardwa | re | | Part In | corre | ct | 7 | Temperature/Cure |
| | | | | | | | Inspecti | on Incomplete/Ur | nqualified | Part Lo | st/Mi | issing | ٦, | Weld | |
| | | Cuffs Contamination | | | | Contamination | | Instruct | ions Incomplete/L | Jnclear | Part M | oved | Ţ | 一, | Wrong Stock Pulled |
| · | Crushing | | | | | Countersink | | Misalig | ned/off center | | Positio | ned V | Vrong | _ | _ |
| | H | leat Trea | t | | | Cut Too Short | | Mislabe | led | | Power | Loss/ | Surge | \Box | Other |
| | Inspection Strip in Tube | | | | | Drawing | | Misread | 1 | _ | | | - L | | |
| | | Marks/Ch | atter | | | Drill Holes | | Off-set | | | | | | | |
| | Turning Sequence | | | | | Finish | | Out of (| Calibration | | | | | | |
| | <u> </u> | Nave/Tw | ist in Tub | e | | Fit/Function | | Out of Sequence | | | | | | | |



| DQA: | | | Date: | | | WORK ORDER NON-CONFORMANCE / UPDATE | | | | | | | |
|--|--|------|-------|-------------|------|---|---------|--|---|------------------------|--------------|--|---|
| QA Closed: | | | Date: | | | WORK ORDER NOW | | JINFOR | MVIAINCE / OI | | Vork Order u | pdate only | AEROSPACE |
| Work Orde | | | | | | DISPOSITION | | _ | | AGAINST D | EPARTMEN | /PROCESS | |
| Part N | - | | | | | Rework Scrap | | | Skid-tube Machining | Crosstube Small Fab | | Water Jet | Engineering Quality |
| NCR N | No. | | | | | Use-as-is Suspected Unapproved | | inern | noforming Large Fab | Finishing Composite | Rec/Sto | ore/Packaging Supplier | Other |
| Root | | | | | Desc | ription of work order update | ı | nitial | Act | tion | Sign & | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Descr | ription | Date | Verification | QC Inspector |
| Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved | | | | | | | | | | | | | |
| | | | | | | | FAI | ULT CAT | EGORY | | | | |
| Landi | Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube | | | | | General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing | | Grain Hardwa Inspecti Instruct Misalig | Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge | | | r tolerance ect lissing Wrong | Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other |
| | Marks/Chatter | | | | | Drill Holes | Off-set | | | | | | |
| | Turning Sequence Wave/Twist in Tube | | | | | Finish Fit/Function | | Out of O | | | | | |